

# Work Order ID 92879

\*92879\*

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Friday, November 09, 2012 1:00:58 PM

Item ID: D4093-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket  
 Start Date: 11/9/2012 Start Qty: 7.00 \*7\* Cust Item ID:  
 Required Date: 11/16/2012 Req'd Qty: 7.00 \*7\* Customer:  
 Reference: REWORK PER ECN 12-660

Approvals: Process Plan: UMF Date: 12-11-09 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4093	D

190

0.00

\*190\*

Mill Conv

Conventional Milling Machine

Memo

PULL FROM STOCK D4093-1 X 7:  
 1 X B82766  
 6 X B85941

REWORK TO NEW DRAWING REV D  
 (ADD HOLE)

0.00

12-11-13

7

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Quality Control

Memo

0.00

12-11-13

7

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Item ID: D4093-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 11/9/2012 Start Qty: 7.00 **\*7\*** Cust Item ID:  
 Required Date: 11/16/2012 Req'd Qty: 7.00 **\*7\*** Customer:  
 Reference: REWORK PER ECN 12-660

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*210*</b>									
HandFinish	Memo	0.00							
Hand Finishing	TOUCH UP WITH ALODINE ON REWORKED AREA								
220	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: <u>81487</u>	0.00							
<b>*230*</b>									
Packaging	Memo	0.00							
Packaging									

7 26 12-11-13

15 12-11-14

7

7x

Sp 12-11-14

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Friday, November 09, 2012 1:00:58 PM

Item ID: D4093-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***Start Date: 11/9/2012 Start Qty: 7.00 **\*7\***

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 7.00 **\*7\***

Customer:

Reference: REWORK PER ECN 12-660

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC21- Final Inspection - Work Order Release

0.00


**\*240\***

QC

Memo

0.00

Quality Control

12/11/15 

W1211.14

# Picklist Print

Friday, November 09, 2012 1:00:57 PM

Page 1

Work Order ID: 92879

Parent Item: D4093-1

Parent Item Name: Bracket

Start Date: 11/9/2012

Required Date: 11/16/2012

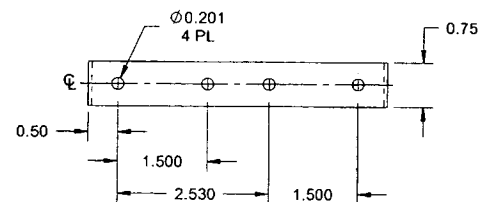
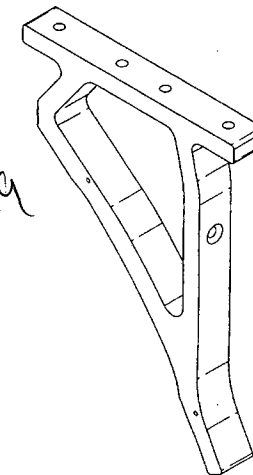
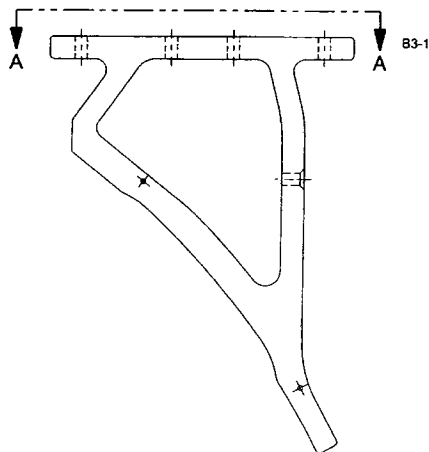
Start Qty: 7.00

Required Qty: 7.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER REV C  
11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4093-1 Bracket		Manufactured	No				Each	0.0000		7			

1 x 82766 } MK  
6 x 85941 }  
12-11-09  
12-11-13  
ST 145  
200



SECTION VIEW A-A D6-1

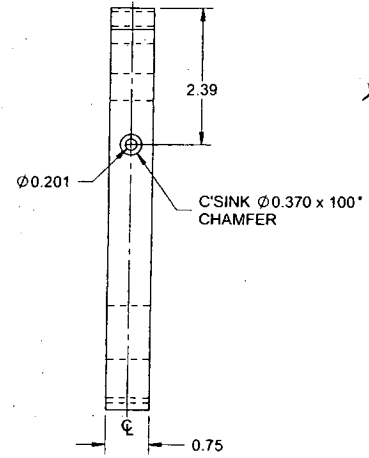
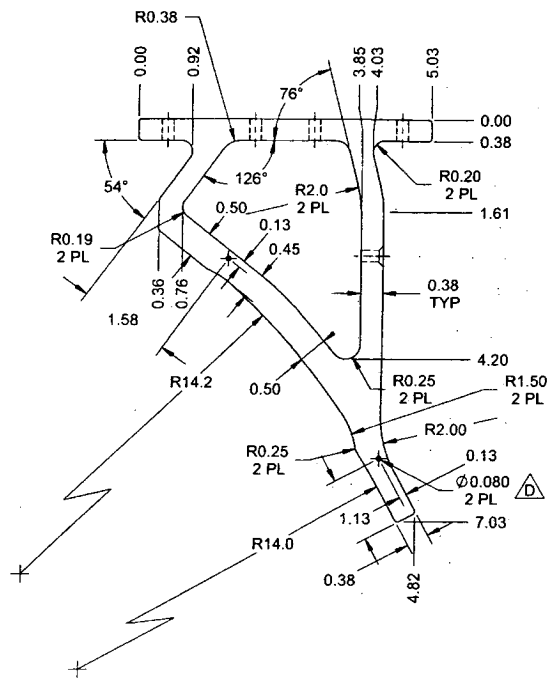
RELEASED  
2012-10-31

# **D4093-1 BRACKET**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs

D	ADD Ø0.080 HOLES (ZN B5-2, B5-4)	RF	12.09.18
C	REDRAWN D4093-1/3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1/3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D4093	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
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#92879

**D4093-1 BRACKET**

**RELEASED**  
2012-10-31

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	<b>D4093</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
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